

Date: Monday, 3/13/2006 7:29:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING BRACKET
Job Number : 26204	
Estimate Number : 10604	
P.O. Number : N/A	Part Number : D2581
This Issue : 3/13/2006 S.O. No. : N/A	Drawing Number : D2581 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 25834	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/30/2006 Qty: 104 Um: Each
Checked & Approved By : <u>06.03.13</u>	
Comment : Est. D 01.07.17 Added info to step 2 SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 800

Laser cut as per Dwg D2581

Material: 304/316 SS 0.125" thick

Material release note required

n *06-03-15*

2.0	D2581F	Mounting Bracket
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Comment: Qty.: 1.0000 U(s)/Unit Total: 104.0000 U(s)
 Mounting Bracket

✓

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

Pd 8/4/3 106

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06-04-04 *106*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

Hermine M

07/04/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/10	8	2 piece were out of Tolerance	JB 06/04/10	Scrap destroy	SB 06/04/10	JB 06-04-10	JB 06/04/10	JB 06-04-10

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 26204

Part Number: D2581

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2581 using CNC Brake

SP

06/04/10

(104)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-10

(104)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

06-04-10 (104)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/11

(104)

Job Completion



u 06-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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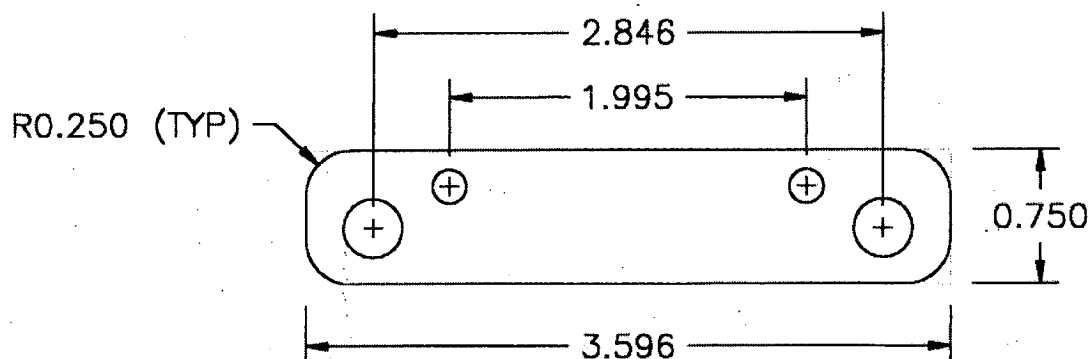
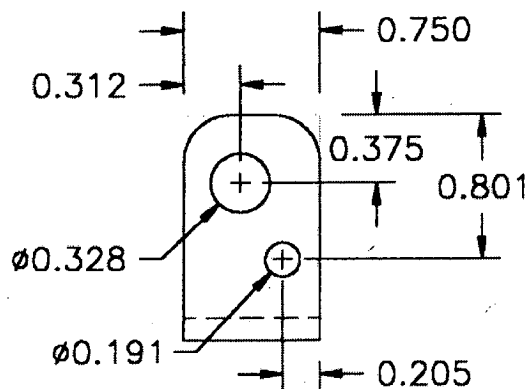
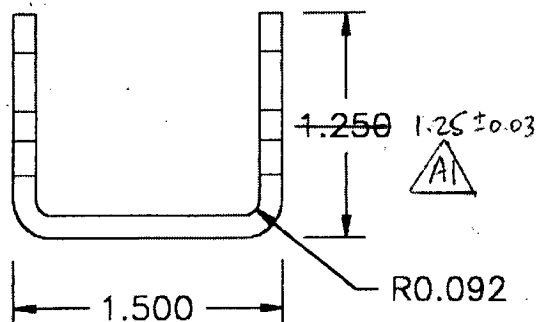
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>MM</i>	D2581	SHEET 1 OF 1
DATE	TITLE		SCALE
96.06.27	MOUNTING BRACKET		1:1
AI	CHANGE TOLERANCE ON 1.25 DIMENSION		

RELEASED
96/07/23 BW



MATERIAL: 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26204

P51020 P0002 80 800

OCT-20-2005 15:06

OLBERT METAL SALES

905 795 1320

P.02

WILKINSON STEEL AND METALS

BL VA-000504-001 20Oct05
Pg 1/1STAINLESS COIL 304
11 GA (114" x 119" X 48.0000")
PART NO.

Certified in accordance to Pressure Equipment Directive 97/23/EC Annex L
Paragraph 4.3 by TÜV Aufsteigstechnik GmbH (Notified Body Identification No.0035)
Inspection Certificate EN10204-3.1B

Shanxi Taigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 Jiancaoping, Taiyuan, Shanxi, P.R.China

TEL: (0351)3013328 FAX: (0351)3017816

http://www.tisco.com.cn

E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish
SPECIFICATION	ASTM A240/A480 ASME SA240/SA180
L/C NO.	
CERTIFICATE NO.	20030636
DATE OF ISSUE	11

CUSTOMER
OLBERT

CONTRACT NO.
1149

DATE OF
0805/06/10

Product	Melting furnace	Inspector's stamp	Mark of the Manufacturer
COIL	8+VOD		Shanxi Taiyuan Stainless Steel Co., Ltd

NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
8	QBP1133	SA4-278-4ZB	1	20GA x 48 x C	8528
9	Y501898	SA4-419-4ZY	1	14GA x 48 x C	5396
10	4501977	SA4-348-1ZB	1	11GA x 48 x C	5182
11	4501969	SA4-416-4ZY	1	14GA x 48 x C	7709
12	4501968	SA4-415-4ZY	1	14GA x 48 x C	7495
13	4501965	SA4-367-1ZB	1	11GA x 48 x C	8127
14	4500491	SA4-18-4ZJ	1	20GA x 48 x C	7668

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
QBP1133	0.049	0.470	1.090	0.023	0.003	18.340	8.050				0.039
Y501898	0.038	0.430	1.090	0.029	0.004	18.420	8.070				0.066
4501977	0.070	0.470	1.310	0.019	0.002	18.050	8.100				0.050
4501969	0.030	0.430	1.270	0.018	0.002	18.020	8.010				0.050
4501968	0.060	0.460	1.350	0.018	0.003	18.120	8.100				0.050
4501965	0.050	0.440	1.320	0.019	0.002	18.140	8.090				0.050
4500491	0.050	0.500	1.340	0.020	0.002	18.040	8.000				0.050

Mechanical Properties

Ten No.	Tensile R _m N/mm ²	R _{0.2} Yield _{0.2%} N/mm ²	R _{0.01} Yield _{0.01%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
QBP1133-T	670	290		55				175
Y501898-T	645	289		60		83		
4501977-T	645	279		60		86		
4501969-T	655	298		61		84		
4501968-T	658	294		58		84		
4501965-T	690	283		60		85		
4500491-T	660	329		60				172

Surface and dimensions controlled: O.K.

Work Inspecto



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Wairuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5337/23317

CUSTOMER		Wilkinson		P50505DI002		SPECIFICATION		ASTMA1008 CS Type A		CERTIFICATE No		TC115838															
CUSTOMER O/N		90-21N-742				PRODUCT		CRA WIDE COIL		PAGE		1 of 1															
MILL O/N		486968				DIMENSIONS		0.033" x 48" x Coil		DATE		02 August 2005															
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)											
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH			
		x100				x1000										x10000		x100		180°				GL =	HRB	()	(feet)
R9-464817-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3					Good				45		2618			
R9-464818-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3					Good				45		2664			
R9-464819-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3					Good				49		2618			
R9-464820-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3					Good				49		2825			
R9-464821-00	779674	6	TR	21	13	17	13	22	17	2	3	1	3					Good				50		1923			
R9-464822-00	779674	6	TR	21	13	17	13	22	17	2	3	1	3					Good				50		1978			

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=r45	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/8
(B)=LOWER YIELD STRESS	(B)=50mm (D)=6.85 x 10 (F)=8"	(B)=r90 (D)=(r0+r90+2r45) / 4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15
					(C)=C+Mn/8+Si/24
					(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
QC METALLURGIST